

# Work Order ID 83847

\*83847\*

Page 1

Thursday, April 26, 2012 1:28:32 PM

Item ID: D3255 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Gasket  
 Start Date: 4/26/2012 Start Qty: 30.00 \*30\* Cust Item ID:  
 Required Date: 5/4/2012 Req'd Qty: 30.00 \*30\* Customer:  
 Reference:

Approvals: Process Plan: 0 Date: 12-04-26 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								

100

0.00

\*100\*

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 16836

Possible Supplier: Mc Master Carr  
 Material: Silicone coated fiberglass cloth per AMS 3320F  
 36' x 36' x 1/16"  
 Certificat of conformaty required

P/N: SIL/F

CY 12/04/27 (54)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

\*110\*

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

12/05/17 (54)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83847

**\*83847\***

Page 2

Thursday, April 26, 2012 1:28:32 PM

Item ID: D3255 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Gasket  
 Start Date: 4/26/2012 Start Qty: 30.00 **\*30\*** Cust Item ID:  
 Required Date: 5/4/2012 Req'd Qty: 30.00 **\*30\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 0.00							<i>Snlos</i> <i>Rolls</i>
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>washer jet.</i>  Memo	0.00 0.00							<i>9x</i> <i>SP</i> <i>12-5-8</i>
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							<i>12/5/8</i> <i>MF</i> <i>12-05-08</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 26, 2012 1:28:36 PM

Page 1

Work Order ID: 83847

**\*83847\***

Parent Item: D3255

**\*D3255\***

Parent Item Name: Gasket

Start Date: 4/26/2012

Required Date: 5/4/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A04.04.06New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SIL/F36X36X1/16		Purchased				100	sf	0.0000	1	<del>30</del> 54			
*SII /F36X36X1/16*									**				
Gasket													

*Per 4/27 (54)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

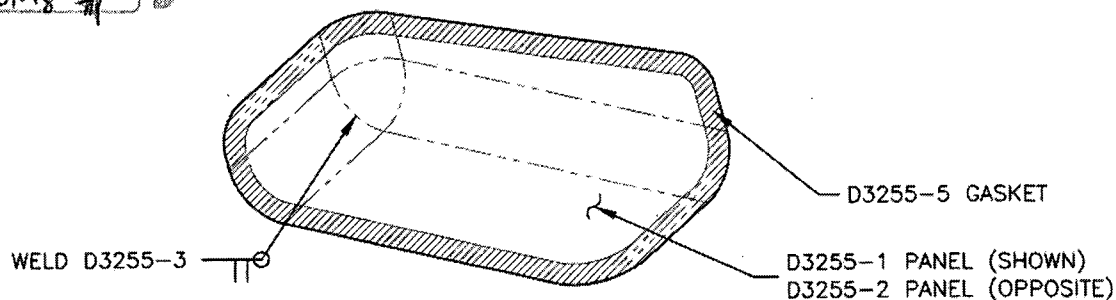
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

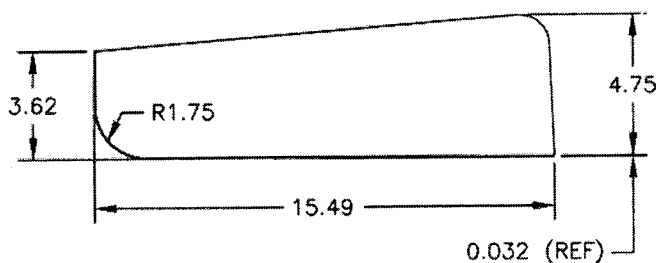
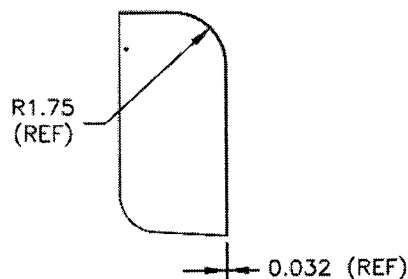
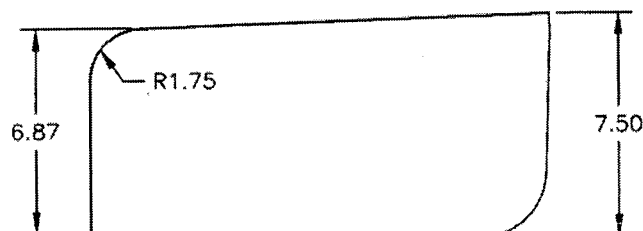


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED  
05.01.18 #



**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 82847

012-0426

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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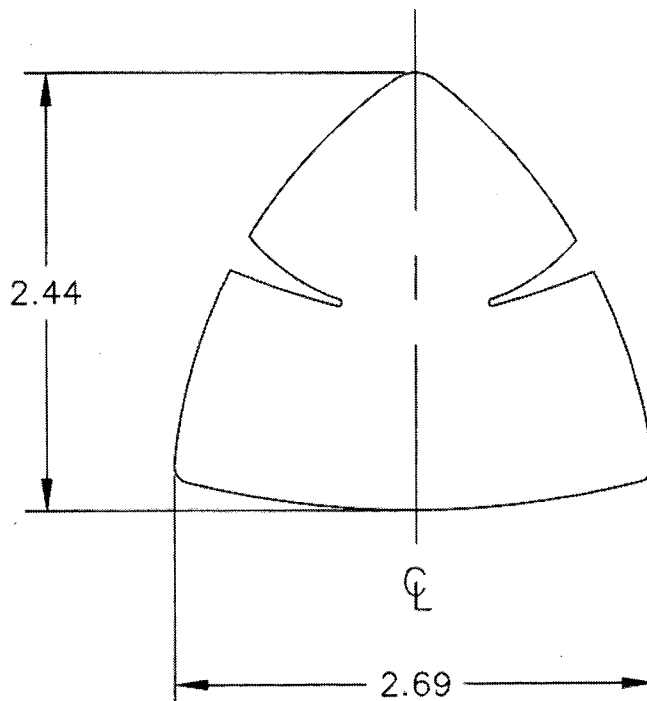
**NOTE:** Date & initial all entries





DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P	APPROVED H	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED  
05.01.18 H



**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

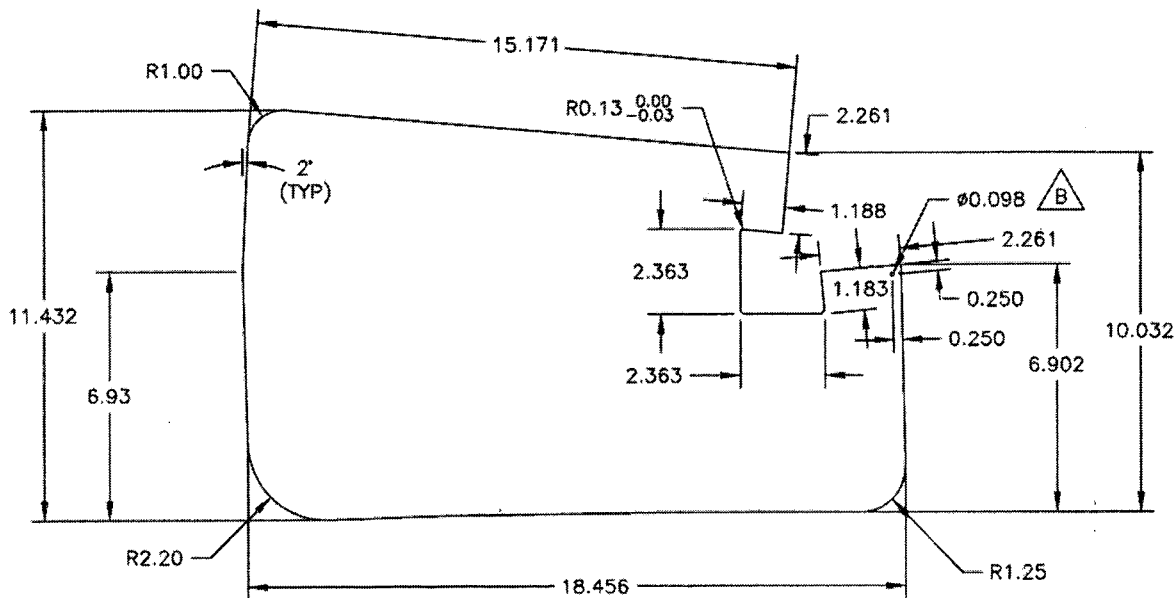
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED RT	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05-01-18



### D3255-1/-2 FLAT PATTERN

#### D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

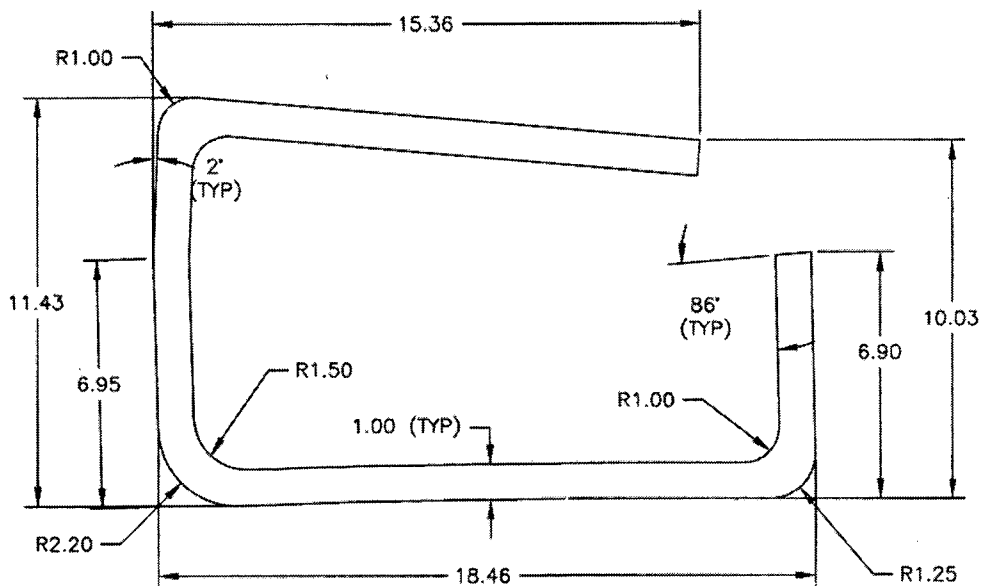
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN JT	DRAWN BY JT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 4P	APPROVED JT	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05.01.18 JT



**D3255-5 GASKET**

83847

**D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

# PURCHASE ORDER

Purchase Order ID PO16836

Purchase Order Date 4/27/12

PO Print Date 4/27/12

Page Number 1 of 1

Order From :

VU-MCM001

MCMASTER-CARR SUPPLY CO,  
P.O. BOX 7690  
CHICAGO, IL 60680-7690  
US

Contact Name

Vendor Phone

330 995 5500

Vendor Fax

330 995 9600

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
4/27/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	SIL/E36X36X1/16	Gasket	5/01/12 Yes	54.00 sf	FedEx PI collect	\$11.9250	\$643.95
		Special Inst:	AS PER DWG D3255 REV. B B75946 MCMASTER P/N: 8612K61				
2		2835T16 CASTERS	5/01/12 Yes	4.00 Each	FedEx PI collect	\$21.1400	\$84.56

Deliver To: HANK

PO Total:

\$728.51



Change Nbr:

1

Change Date: 4/27/12

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



Purchase Order  
PO16836

Page 1 of 1

100 Aurora Industrial Pkwy  
Aurora OH 44202-8087  
330-995-5500  
le.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

McMaster-Carr Number  
4214736-03

04/27/2012

Line	Description	Ordered	Shipped				
8612K61	Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36", 1 EA=6 Sf	9 Each	8	8 - 64 - 37	86 - 73	K61	8 EA 1
				21 lbs			
	Unit Price:	\$71.55					
	Extended Price:	\$572.40					

Shipped separately from our Chicago warehouse on 04/27

8612K61	Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36"	9 Each	1
---------	--	-----------	---

Charges for this shipment

Merchandise Amount:	\$572.40
<b>Total:</b>	<b>\$572.40</b>

Dart Aerospace Ltd

EXP  
INV  
NAFTA



21 lbs  
1 line

FW1RFV43  
04/27/2012  
11:48/12:17  
868  
Cycle 35

Lg

38x12x12

1140359979105







Purchase Order  
PO16836

Page 1 of 1

200 Aurora Industrial Pkwy  
Aurora OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

McMaster-Carr Number  
4214736-01

04/27/2012

Line	Description	Ordered	Shipped	
1	8612K61 Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36", 1 EA=6 Sf	9 Each	1	8 - 36 - 49 45 - 78 K61 1 EA 1
	Unit Price:	\$71.55		
	Extended Price:	\$71.55		

Shipped separately from our Cleveland warehouse on 04/27

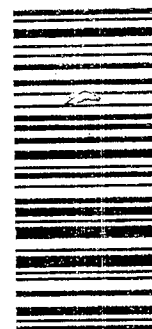
1	8612K61 Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36"	9 Each	8
2	2835T16 Mighty-Lite Caster, Swivel, 5" X1-1/4" Rubber, Brake, 175# Capacity, Roller Bearing	4 Each	4

Charges for this shipment

Merchandise Amount:	\$71.55
<b>Total:</b>	<b>\$71.55</b>

Dart Aerospace Ltd

EXP  
INV  
NAFT



3 lb  
1 lin

EW1VH098  
04/27/2012  
11:48/12:04  
466  
Cycle 31

1140359779103

